

Monday, June 14, 2010 2:31:26 PM

Page 1

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Process Plan:

Date: 10-6-14

Tooling:

Date:

Run Start

OC:

Date:

SPC (Y/N):

Date:

Stop

**Insp.
Stamp**

Revision Nbr

Rev A

100

0.00

Large Fab

Large Fab

Large Fab

Memo

0.00

1- cut D3838-1 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

4- weld D3838-1 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: 111679

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: 111679

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

SAD 10-06-28

Q

Pl 10.00.29

Work Order ID 59846

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Page 2

Item ID:	D3838-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Rib Assembly (Basket Lid, LH)				Stop	
Start Date:	6/14/2010	Start Qty:	2.00			
Required Date:	6/18/2010	Req'd Qty:	2.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							② 10.07.01
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8.10.07.01					④ 10.07.01
150 Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u> Memo	0.00 0.00							③ 10.07.01

Work Order ID 59846

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Page 3

Item ID: D3838-041

Accept



Setup Start



Revision ID:

Item Name: Rib Assembly (Basket Lid, LH)

Stop



Start Date: 6/14/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 6/18/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 *[Signature]*

mf

10-0-01

Picklist Print

Monday, June 14, 2010 2:31:31 PM

Page 1

Work Order ID: 59846

Parent Item: D3838-041

Parent Item Name: Rib Assembly (Basket Lid, LH)

Start Date: 6/14/2010

Required Date: 6/18/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Manufactured No



Bushing

Each 16.0000 1 2



Pl 10-06-29

Location

Loc Qty

Loc Code

WA	16	
54072	9	
58672	7	

359644 → (2)

M304TS0.750W.065 Purchased No



304 SQ Tube .75x.75x.065W

100 f 938.4760 1.0317 2.172



SAO 10-06-24

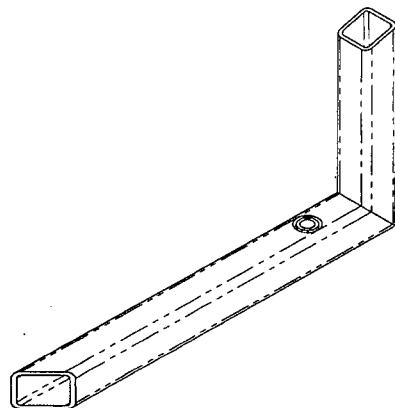
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Loc Qty

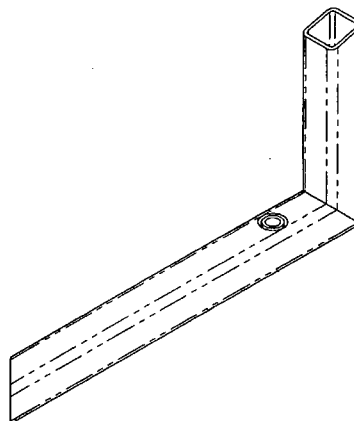
Loc Code

MAT	53.32232	
112398	0	
114482	53.32232	
WA	885.1537	
114520	885.1537	

2.172



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

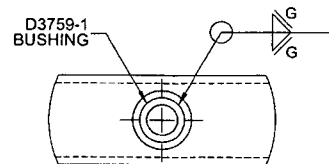
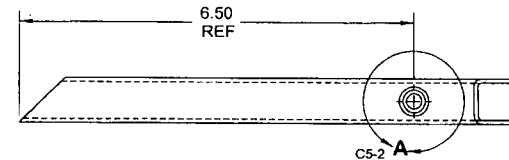
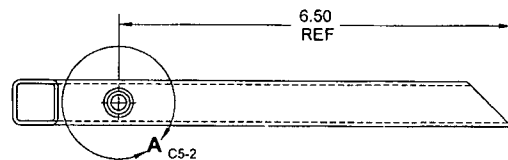
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59846

PS 10-6-14

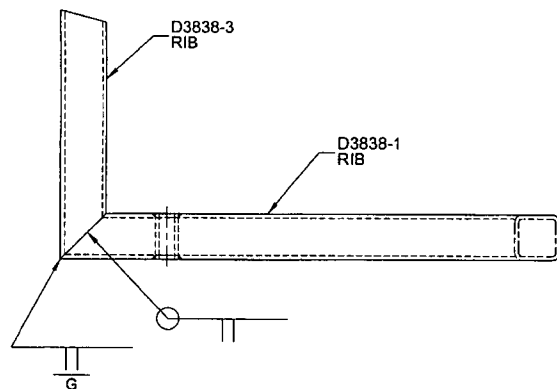
RELEASED
08/11/14

- NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.54 lbs

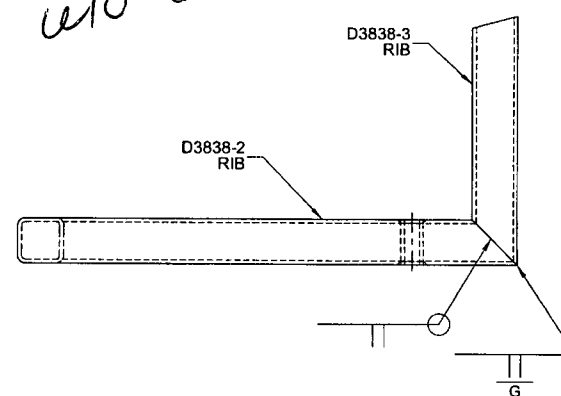
A	NEW ISSUE	MB	08.10.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3838	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
DATE	08.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



DETAIL A
D2-2
D7-2 SCALE 2X



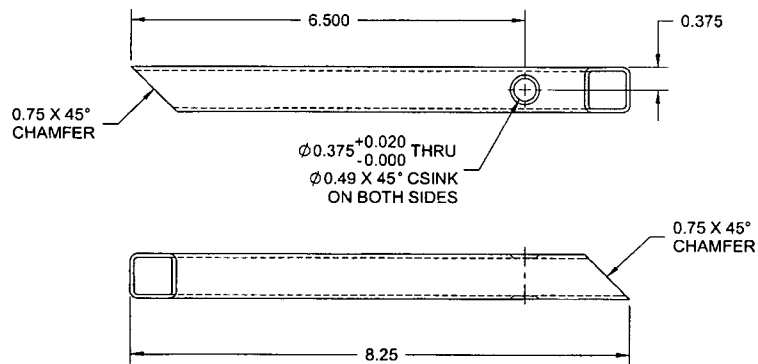
D3838-041 RIB ASSY (BASKET LID, LH)



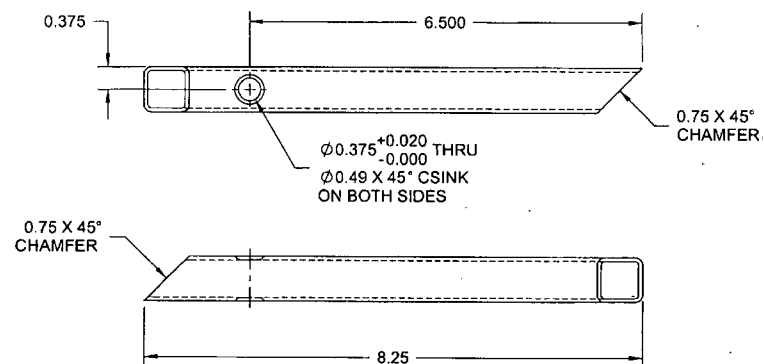
D3838-042 RIB ASSY (BASKET LID, LH)

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08/11/18/14

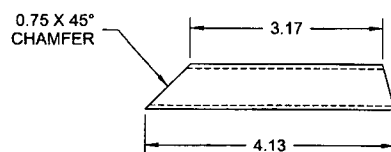
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CHECKED	SS	DRAWING NO. D3838	REV. A
MFG. APPR.			SHEET 2 OF 3
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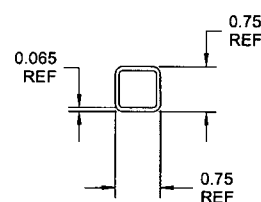
D3838-1 RIB



D3838-2 RIB



D3838-3 RIB



TYPICAL SECTION VIEW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3838-1/2 = 0.35 lbs EACH; D3838-3 = 0.19 lbs

w/b 59846

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APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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